

Date: Thursday, 5/4/2006 11:10:09 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET ASSEMBLY  
 Job Number : 26933  
 Estimate Number : 10397  
 P.O. Number : N/A Part Number : D3155042  
 This Issue : 5/4/2006 S.O. No. : N/A Drawing Number : D3155 REV C  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : R & D SM/MED FAB Drawing Revision : C  
 Previous Run : 25283 Material : N/A  
 Written By : Due Date : 5/30/2006 Qty: Um: Each  
 Checked & Approved By :  
 Comment : Est B 03.02.03 Reformat KJ/RF

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B1000X02000 6061-T6 Bar 1.0" x 2.0"



Comment: Qty.: 0.6125 f(s)/Unit Total: 2.4499 f(s)

Material: 6061-T6/-T651 (QQ-A-200/8 or QQ-A-225/8)

(M6061T6B2.000x01.000)

Batch: M101000

SD 06.05.20

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blanks: (2.000" x 1.000") x 6.87" Long Bar

SD 06.05.20

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA315 and Dwg D3155

2-Deburr and Tumble

JL 06/05/24

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE


JL 06/05/24

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

MS 06/05/24

Date	Step	Procedure Change	By	Date	Qty	APPROVAL
06/06/27	7	<del>Re</del> stock part D 3155-052	SB	06/06/27	3	 Date 06/07/27 Adj 1614

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 26933

Part Number: D3155042

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*u.m 06-06-05-*

*(10)*

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*SB 06/06/27 (3)*

8.0

D31553

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Bracket Assembly

Qty

Part-number

Description

Batch

2

D3155-3

Bushing

*B27129 (15)*

*N/A*

*SB 06/06/27*

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press fit bushing as per Dwg D3155

*N/A*

*SB 06/06/27*

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*N/A*

*SB 06/06/27*

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

*ST 410*

*(50)*

*SB 06/06/27 (3)*

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

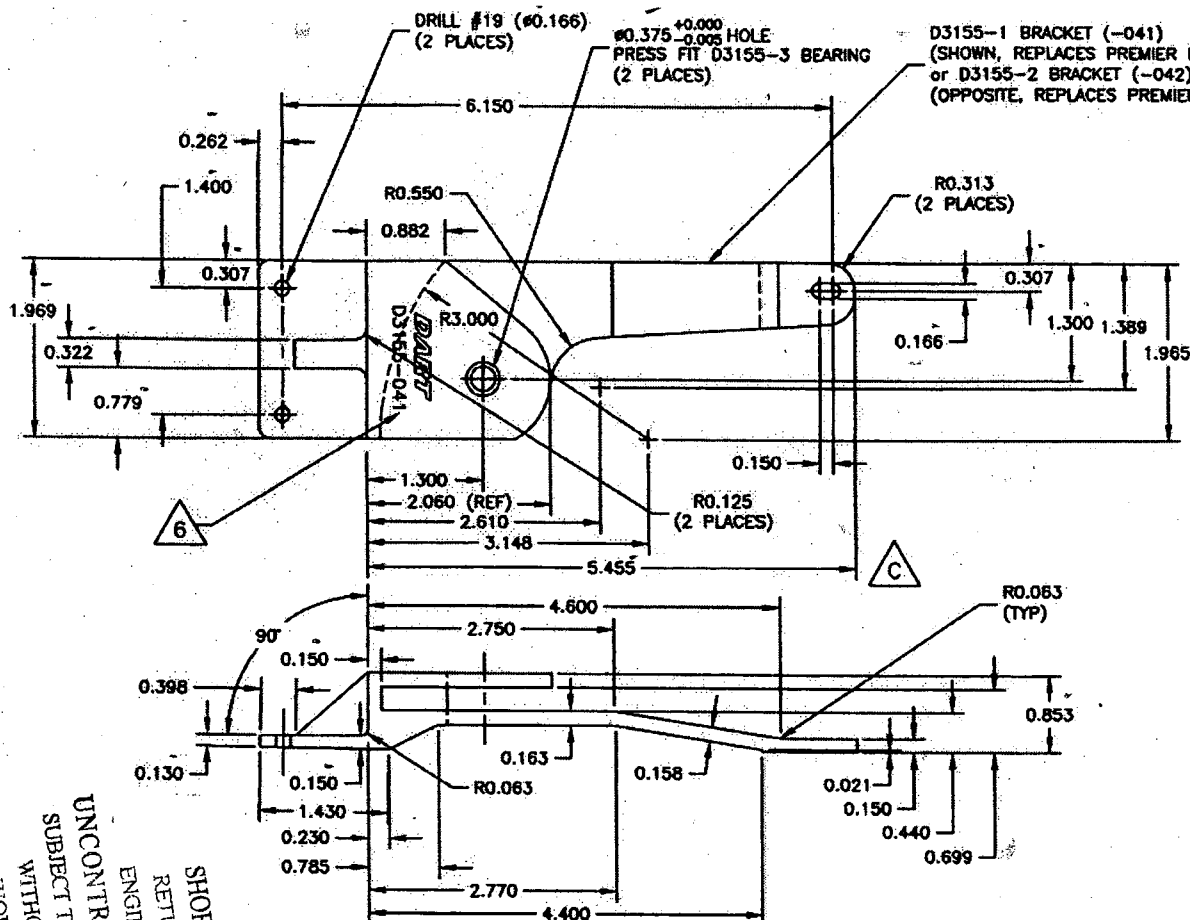
*(3)*

*LD 06/06/27*



**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
DATE		D3155	SHEET 1 OF 2
04.10.06		TITLE	SCALE
		BRACKET ASSEMBLY	1:2
A	02.04.24	NEW ISSUE	
B	03.02.28	AS MANUFACTURED	
C	04.10.06	5.455 WAS 5.550	



**D3155-041 BRACKET ASSEMBLY**  
(SHOWN, REPLACES PREMIER P/N B30-23000-11)  
**D3155-042 BRACKET ASSEMBLY**  
(OPPOSITE, REPLACES PREMIER P/N B30-23000-12)

**D3155-1/-2 BRACKET**

- 1) MATERIAL: 6061-T6/-T651 (QQ-A-200/8 OR QQ-A-225/8) BAR  
(REF DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO AS SHOWN

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 26933

RELEASED  
104123

AEROSPACE LTD		Work Order: 26933
Description: bracket assembly		Part Number: D3155042
Inspection Dwg: D3155	Rev: C	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .166	+ .005 - 0	.169	✓			
Ø .375	+ 0 - .005	.375	✓			
6.150	+ .010	6.148	✓			
.262	"	.262	✓			
1.400	"	1.400	✓			
.307	"	.307	✓			
1.969	"	1.970	✓			
.322	"	.322	✓			
.779	"	.780	✓			
.166	"	.168	✓			
.307	"	.309	✓			
1.300	"	1.298	✓			
.130	"	.130	✓			
.150	"	.148	✓			
.150	"	.153	✓			
.853	"	.848	✓			
.158	"	.162	✓			
.163	"	.169	✓			
1.063	"	.063	✓			
5.455	"	5.458	✓			
4.600	"	4.594	✓			
2.060	"	2.060	✓			
.021	"	.023	✓			

Measured by: J.L.	Audited by: MK	Prototype Approval:
Date: 06/05/23	Date: 06/05/23	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	